

Date: Friday, 9/15/2006 11:55:41 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTSIDE WASHER
Job Number	: 28611		
Estimate Number	: 11153		
P.O. Number	: N/A	Part Number	: D32333
This Issue	: 9/15/2006 S.O. No. : N/A	Drawing Number	: D3233 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 9/30/2006
Checked & Approved By	: <u>[Signature]</u>	Qty:	20 Um: Each
Comment	: Est. B 05.03.31 Added Powder Coat KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1020TR2000W500	1020-1025 Round Tube
-----	-----------------	----------------------



Comment: Qty.: 0.7875 f(s)/Unit Total: 15.7500 f(s)
 1020-1025 Round Tube
 Material: AISI 1020-1025 Seamless Tubing 2" x 0.500" wall
 (M1020TR2.000W.500)
 Identify for D3233-3
 Batch: M17015

J.F. 06/09/21

Q2

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL
 Turn as per Folio FA518 and Dwg D3233
 Deburr

J.F. 06/09/25

J.F. 06/09/21

Q2

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/09/21

Q2

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.F. 06/09/25

Q2

5.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING
 Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

J.F. 06/10/30 x22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/11/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-07-25	2-0	faults punched						

NOTE: Date & initial all entries

Date: Friday, 9/15/2006 11:55:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTSIDE WASHER

Job Number: 28611

Part Number: D32333

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/10/31 (22)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

03 06/10/31 (22)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(22)

06/11/01

Job Completion



06.11.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

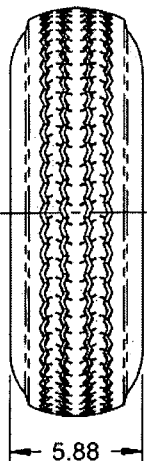
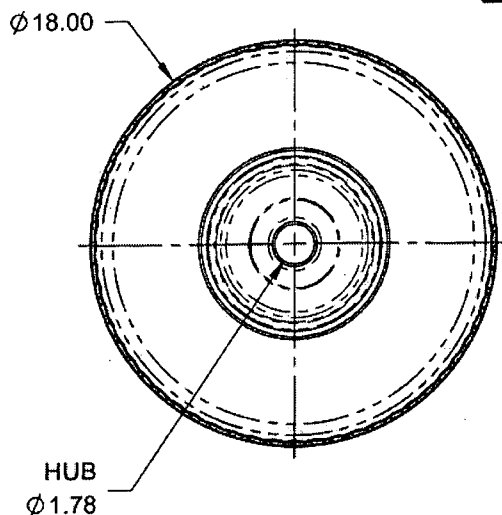
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



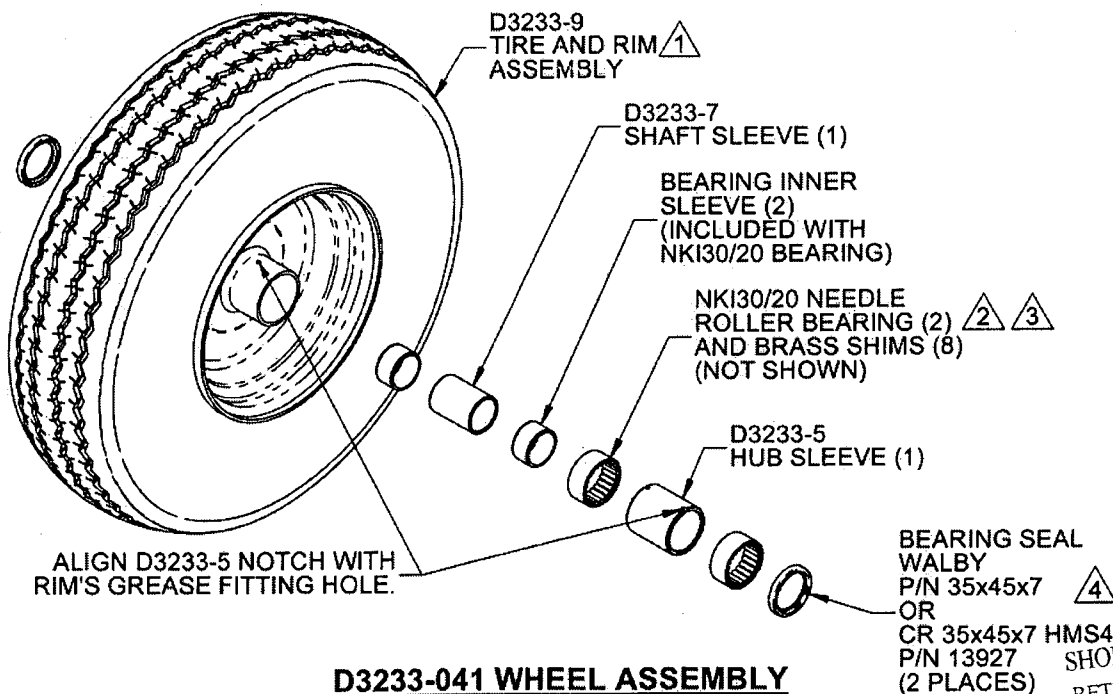
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	



RELEASED
[Signature]
05/05/04

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

* MANUFACTURER'S RECOMENDATIONS ARE 75 PSI FOR HIGH SPEED USE.



D3233-041 WHEEL ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH (4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

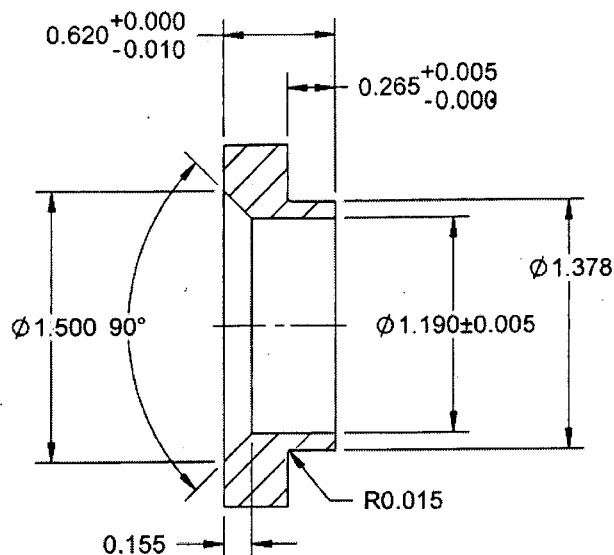
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28611

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

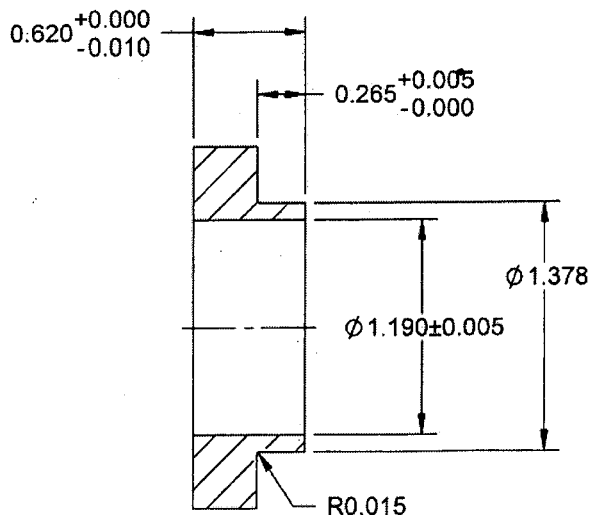
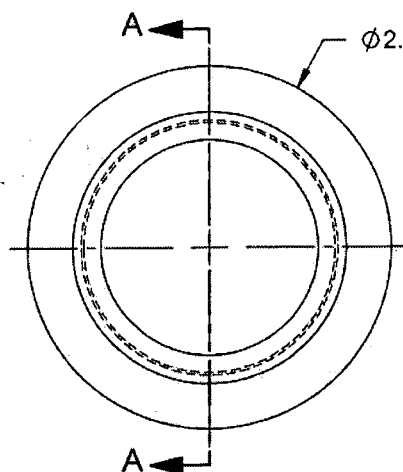


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 2 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1



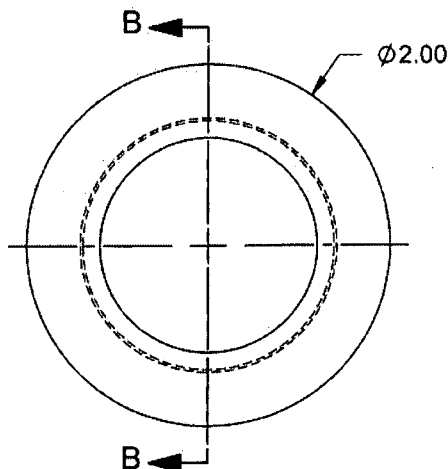
SECTION A-A

D3233-1 INSIDE WASHER



SECTION B-B

D3233-3 OUTSIDE WASHER



NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00, MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 28611

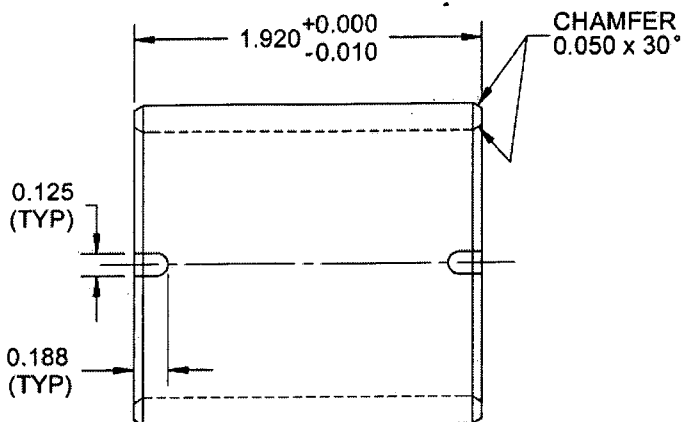
COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

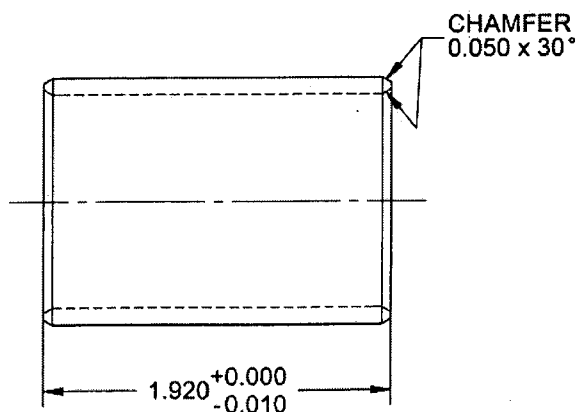
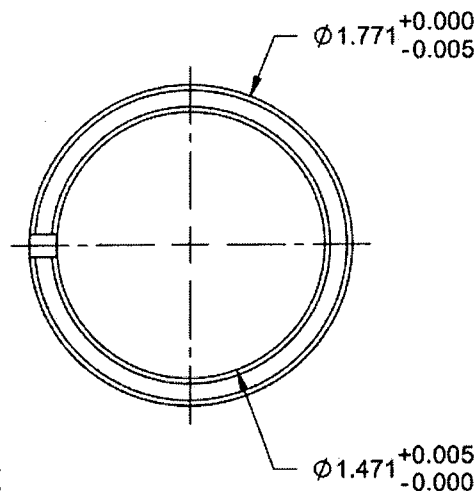


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

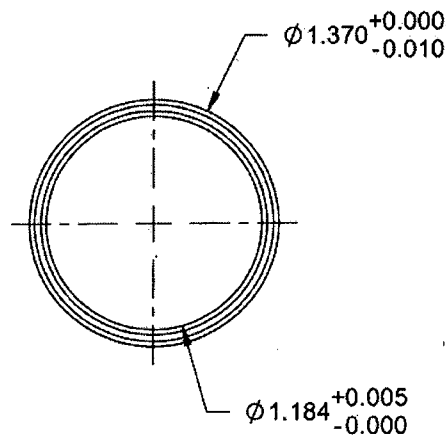
RELEASED
[Signature]
05/05/04



D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE



NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **28611**

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.